

Blue

Work Order ID 53328

October 30, 2009 10:59:24 AM



SPLIT-2

Item ID: D2933-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: Saddle LH In, 206

Start Date: 30/10/2009 Start Qty: ~~8.00~~ 6



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan: *PS*

Date: *09-10-30* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2933

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

8/09/10/11

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00



Mill Conv

CONVENTIONAL MILLING MACHINE

Memo

0.00

8/09/11/10

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC

QC1- Inspect dimensions to dimension sheet

Memo

0.00

8/09/10/10

Quality Control

Work Order ID 53328

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Start Date: 30/10/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Jan 09-11-11

(8)

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

mo 09/11/11

x8

Hand Finishing

155

Spray Painting per QSI005 4.2

0.00



SprayPaint

Memo

0.00

ml 09 11 16 (2)

Spray Painting

Jan 09-10-30

- 1 - Prime B 110199
- 2 - Paint Reflect Blue B 113171
- 3 - Clear Reflect B 113033

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Setup Start



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Start Date: 30/10/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

165

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

25 09-11-17 (2)

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

C 9/11/17 (2)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/17 (2)
MF 09-11-17

Picklist Print

October 30, 2009 10:59:28 AM

Page 1

Work Order ID: 53328



Parent Item: D2933-1RevC



Parent Item Name: Saddle LH In, 206

Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-001RevB		Manufactured	No			100	Each	0.0000	8.0000			

Saddle Billet

SP 09/10/10
Batch: 46409 X 8

DART AEROSPACE LTD		Work Order:	53328
Description: 206 Saddle, Inboard, Left side		Part Number:	D2933-1
Inspection Dwg: D2933	Rev: C	DSK:	Rev:
			Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	
A	0.100	0.140		.111	.117	.118	.121	
B	0.100	0.140		.113	.118	.120	.120	
C	0.100	0.140		.125	.120	.125	.130	
D	0.210	0.230		.228	.225	.225	.223	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.511	.511	.510	.510	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.259	.259	.259	.259	
L	0.312	0.317		.314	.314	.314	.314	
M	0.235	0.240		.239	.238	.239	.239	
N	0.100	0.140		.109	.111	.111	.110	
O	0.540	0.560		.549	.550	.549	.550	
P	0.490	0.510		.500	.501	.502	.502	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.470	2.510		2.495	2.495	2.495	2.495	
S	0.240	0.270		.258	.250	.248	.250	
T	0.100	0.180		.135	.135	.135	.135	
U	1.625	1.635		1.630	1.630	1.630	1.630	
V	1.362	1.372		1.368	1.368	1.368	1.368	
W	0.316	0.321		.320	.320	.320	.320	
X	1.125	1.145		1.137	1.138	1.138	1.135	
Y	1.565	1.585		1.575	1.577	1.571	1.575	
Z	0.178	0.198		.188	.183	.188	.188	
AA								
AB								
AC								
AD								
AE								

Accept/Reject

Measured by:	RF	Date:	09/11/10
Audited by:	[Signature]	Date:	09.11.11
Prototype Approval:	N/A	Date:	N/A

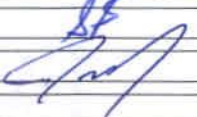

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	[Signature]



DART AEROSPACE LTD				Work Order: 53928	
Description: 206 Saddle, Inboard, Left side				Part Number: D2933-1	
Inspection Dwg: D2933 Rev: C DSK: Rev:				Page 1 of 1	

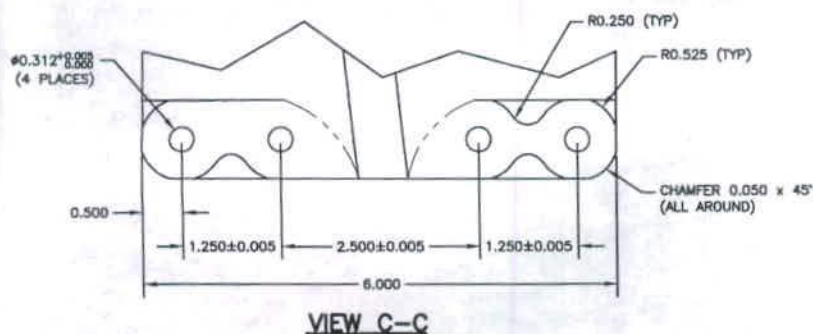
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	5x	6x	7x	8x	9x
A	0.100	0.140		.125	.125	.120	.120	
B	0.100	0.140		.120	.120	.120	.120	
C	0.100	0.140		.130	.130	.130	.130	
D	0.210	0.230		.225	.225	.225	.225	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.510	.510	.510	.510	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.259	.259	.259	.259	
L	0.312	0.317		.314	.314	.314	.314	
M	0.235	0.240		.239	.239	.239	.239	
N	0.100	0.140		.110	.111	.110	.111	
O	0.540	0.560		.550	.550	.550	.550	
P	0.490	0.510		.500	.502	.502	.500	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.470	2.510		2.490	2.490	2.493	2.490	
S	0.240	0.270		.250	.250	.250	.250	
T	0.100	0.180		.190	.190	.190	.190	
U	1.625	1.635		1.630	1.630	1.630	1.630	
V	1.362	1.372		1.368	1.368	1.368	1.368	
W	0.316	0.321		.320	.320	.320	.320	
X	1.125	1.145		1.135	1.135	1.130	1.130	
Y	1.565	1.585		1.575	1.575	1.572	1.572	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

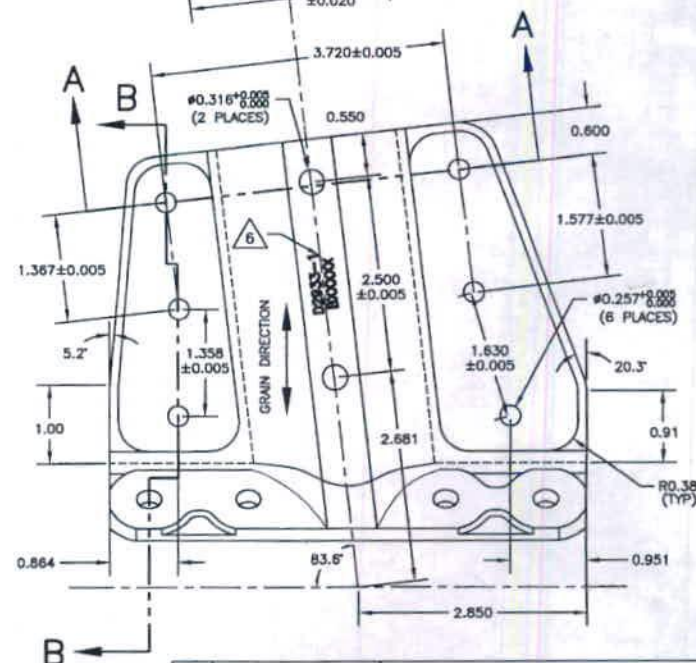
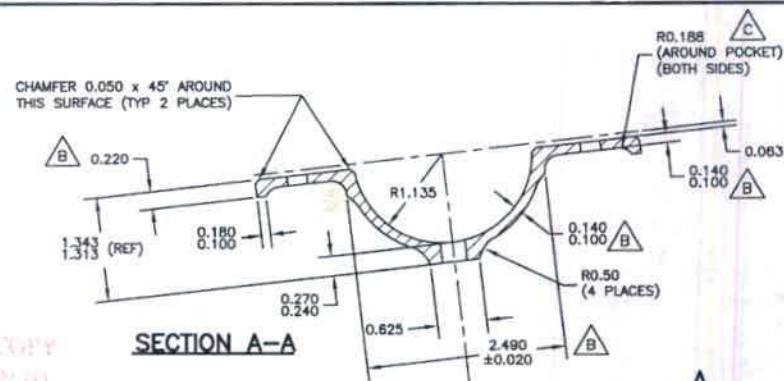
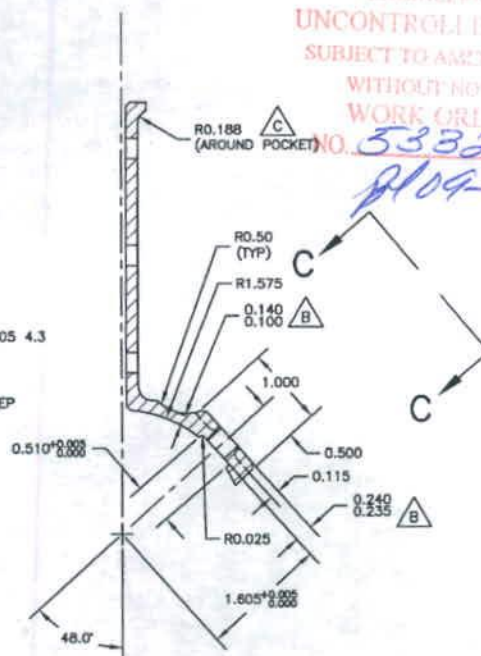
Measured by: 	Date: 09/11/10
Audited by: 	Date: 09-11-11
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
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C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD 	



D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	PH	DRAWING NO. D2933
DATE	06.11.09	TITLE SADDLE INSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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07-02-12

